



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2739

Job Sheet 172903



Part No: D2739

Job Qty: 13 ea

Part Name: 350 I-Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/22/18

Job Tracking No:

Due Date: 3/5/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG D2739 REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F 10.11.02 as per revE DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	13 Ea		3/2/18	0.00	0.00	Start Up Skid tubes-2		SL
100	Skid tubes	13 pcs		3/3/18	0.00	7.03	Skid tubes-3		SL MGR
120	HandFinish	13 pcs		3/5/18	0.00	1.08	HandFinish1		SA 18-03-09
130	QC	13 pcs		3/5/18	0.00	0.00	QC5		X SL
140	Packaging	13 pcs		3/5/18	0.00	0.00	Packaging3-1		SL
150	QC21-SA	13 Ea		3/5/18	0.00	0.00	QC21		SL 18/03/13

Part Op 100 - 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 3-Descriptions: Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends.

140 - LOCATION : LG002

DAS
21
9-80

MAR 13 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-5-108	Extrusion I-Beam Thin	13 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-5-108	13	118	0



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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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www.dartaerospace.com

Container No: S049038



Part: D2739

Job No: 172903

Serial No/Batch: S049038

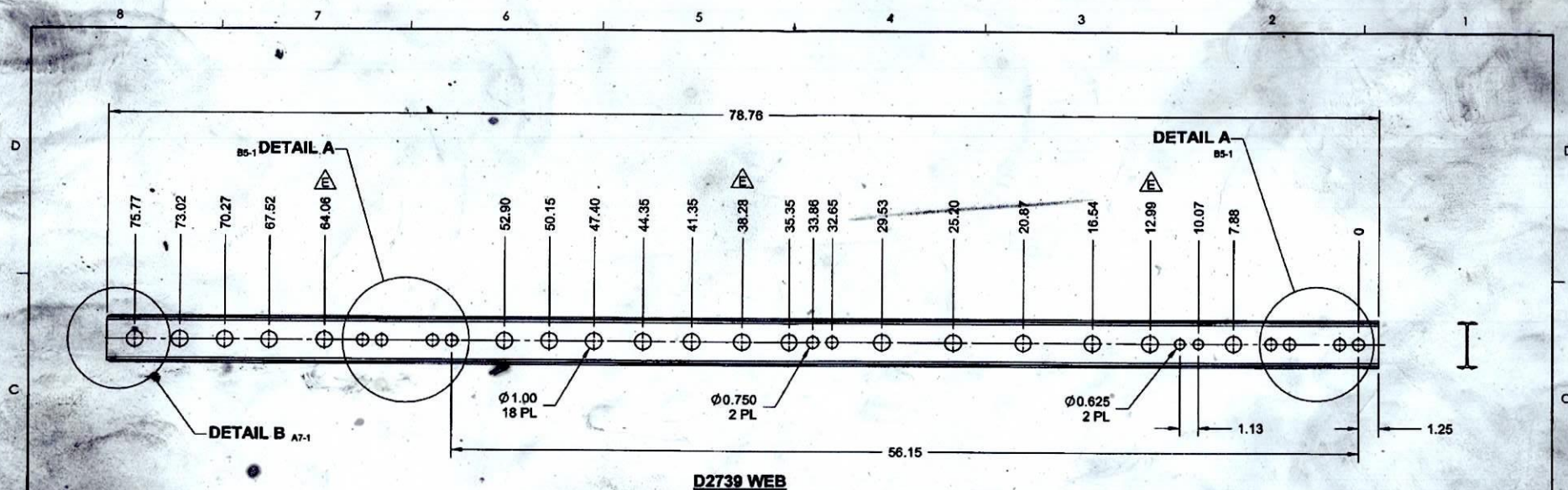
Revision:

Inspector:

Date: 03/08/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Web	78.760Inches $\pm$ 0.030	78.790 78.730		
2	Web	1.180Inches $\pm$ 0.010	1.190 1.170		
3	Web	3.150Inches $\pm$ 0.010	3.160 3.140		
4	Web	1.180Inches $\pm$ 0.010	1.190 1.170		
5	Web	0.250Inches $\pm$ 0.030	0.280 0.220		
6	Web	30.000Degrees + 0.500 - 5.000	30.500 25.000	Angle	
7	Web	1.250Inches $\pm$ 0.030	1.280 1.220		
8	Web	7.880Inches $\pm$ 0.030	7.910 7.850		
9	Web	10.070Inches $\pm$ 0.030	10.100 10.040		
10	Web	12.990Inches $\pm$ 0.030	13.020 12.960		
11	Web	16.540Inches $\pm$ 0.030	16.570 16.510		
12	Web	20.870Inches $\pm$ 0.030	20.900 20.840		
13	Web	25.200Inches $\pm$ 0.030	25.230 25.170		
14	Web	29.530Inches $\pm$ 0.030	29.560 29.500		
15	Web	32.650Inches $\pm$ 0.030	32.680 32.620		
16	Web	33.860Inches $\pm$ 0.030	33.890 33.830		
17	Web	35.350Inches $\pm$ 0.030	35.380 35.320		
18	Web	38.280Inches $\pm$ 0.030	38.310 38.250		
19	Web	41.350Inches $\pm$ 0.030	41.380 41.320		
20	Web	44.350Inches $\pm$ 0.030	44.380 44.320		
21	Web	47.400Inches $\pm$ 0.030	47.430 47.370		
22	Web	50.150Inches $\pm$ 0.030	50.180 50.120		
23	Web	52.900Inches $\pm$ 0.030	52.930 52.870		
24	Web	64.060Inches $\pm$ 0.030	64.090 64.030		
25	Web	70.270Inches $\pm$ 0.030	70.300 70.240		
26	Web	73.020Inches $\pm$ 0.030	73.050 72.990		
27	Web	75.770Inches $\pm$ 0.030	75.800 75.740		
28	Web	56.150Inches $\pm$ 0.030	56.180 56.120		

Plex 2/22/18 2:27 PM dart.logan.david



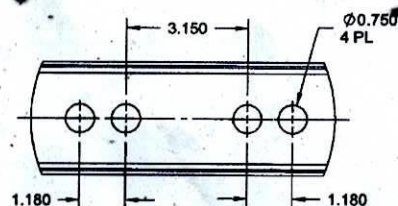
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WORK ORDER
NO. 172903

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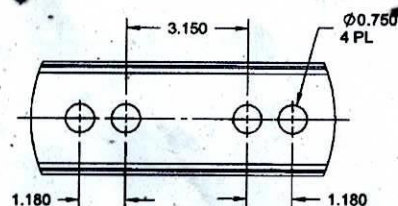
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RELEASED
2010-11-01

DETAIL B
SCALE 3X



DETAIL A
SCALE 3X



NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044-6.1
- 7) WEIGHT: 3.41 lbs

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (D5-1), 64.06 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CS	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER	CP	06.11.18
A	NEW ISSUE	DS	06.04.10
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	10.10.08		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO.
D2739
REV. E
SHEET 1 OF 1
TITLE
WEB
SCALE
NTS

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